

Need Tube 1st

Dart Aerospace Ltd.

Date: Friday, 5/25/2007 8:21:08 AM  
User: Kim Johnston

## Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	BRACKET
Job Number	32606			
Estimate Number	12840			
P.O. Number	N/A		Part Number	D35421
This Issue	5/25/2007	S.O. No. N/A	Drawing Number	D3542 REV A
Prsht Rev.	NC		Project Number	N/A
First Issue	N/A	Type MACHINED PARTS	Drawing Revision	A
Previous Run	32129		Material	N/A
Written By			Due Date	6/6/2007
Checked & Approved By			Qty:	20
Comment	Est Rev: A	New Issue 07-04-23 JLM	Um:	Each
	Est Rev: B	updated powder coat per NCR 07.05.16 EC		

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M6061T6B3000X01500	6061-T6 Bar 3" x 1.5"	
		Comment: Qty.: 0.3500 f(s)/Unit Total : 6.9993 f(s)	
		6061-T6 Bar 3" x 1.5"	
		BATCH: M16530	J.F. 07/05/30
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1	
		1- Mill as per Folio FA684 Rev: AA & Dwg D3542 Rev: A	
		2-Deburr per dwg D3443	21 07/05/31
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	J.L. 07/05/31
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	21 07/05/31
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1	
		Chemical Conversion Coat as per QSI 005 4.1	SL 07/06/04 (20)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes Yes No No DQA: D Date: 07/06/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:21:08 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 32606

Part Number: D35421

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 POWDER COATING



POWDER COATING

*m 10/601*



Comment: POWDER COATING

Powder Coat Grey sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

\*\*\*\*\*ENSURE TO MASK INSIDE BORE\*\*\*\*\*

*FZ*

*07/06/04 (20)*

7.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*M-A 07/06/04*

8.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *37243*

*6/2/05 (21)*

9.0 QC21



FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*6/2/05 (21)*

Job Completion



*6/2/05*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

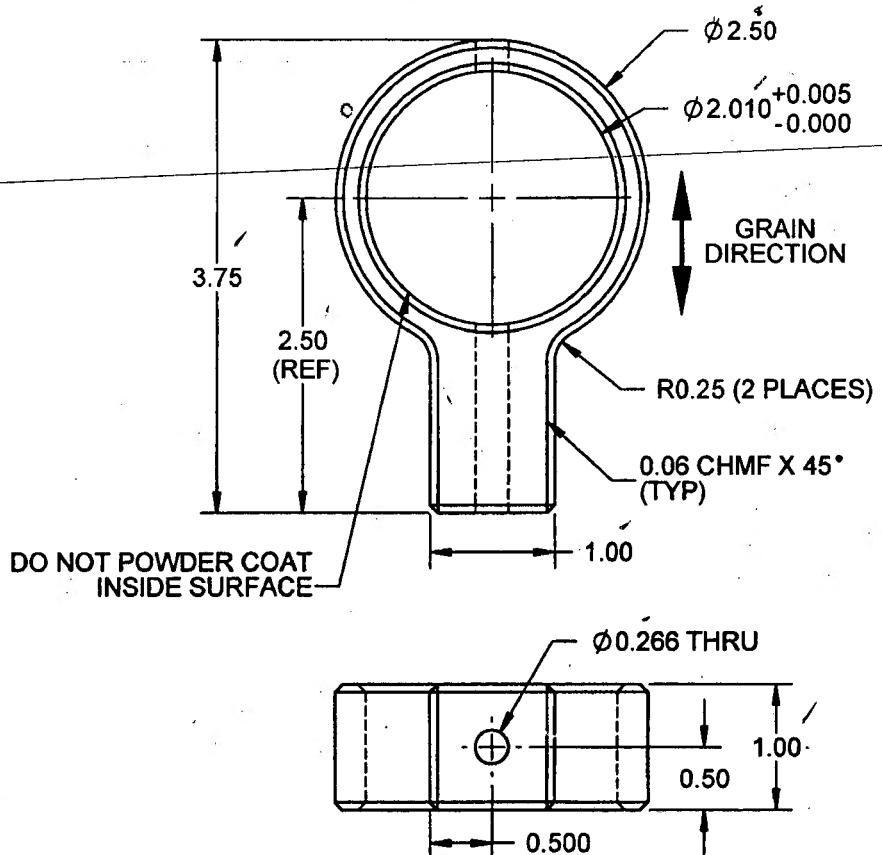
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



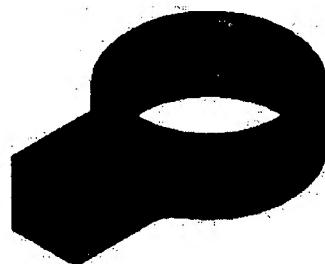
DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3542
DATE 06.11.27		REV. A SHEET 1 OF 1
		SCALE 2:3
REV A	DATE 06.11.27	DESCRIPTION NEW ISSUE

RELEASED  
07.04.02



### D3542-1 BRACKET

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *32606*



#### NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160  
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3 EXCEPT WHERE NOTED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3542-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD	Work Order:	32606
Description: bracket	Part Number:	D 3542-1
Inspection Dwg: A3542	Rev: A	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	J.L.
Date:	07/05/31

Audited by:	D.V.
Date:	07/05/13

<b>Prototype Approval:</b>	
<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

14